

Date: Friday, 11/17/2006 9:08:14 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 29517		
Estimate Number	: 11873		
P.O. Number	: <i>N/A</i>	Part Number	: D335315
This Issue	: 11/17/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3353 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 28329	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/5/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	4 Um: Each
Comment	: est rev. A 06.01.14 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X0200	1010-1025 BAR
-----	-----------------	---------------



Comment: Qty.: 0.2520 f(s)/Unit Total : 1.0080 f(s)

1010-1025 BAR

AISI 1010-1025 Steel bar 2.00" x 0.750"

Batch: *M15925**J.G**06/12/05*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 2.870" long

*J.G**06/12/05**4*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA613 and Dwg D3353

2- Deburr

*J.L 06/12/05**(H)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L 06/12/05**(H)*

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*ML 06/12/05**(H)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: RD Date: 06/12/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:08:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 29517

Part Number: D335315

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identified ST428

0306/12/07

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/08 *(4)*

Job Completion



11 06/12/08

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29517
Description: Lock Bracket		Part Number:	D3353-15
Inspection Dwg: D3353 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.748	✓			
1.20	+/-0.030	1.201	✓			
R0.156	+/-0.010	.156	✓			
0.460	+/-0.010	.468	✓			
0.80	+/-0.030	.802	✓			
0.800	+/-0.010	.801	✓			
2.75	+/-0.010	2.758	✓			
0.950	+/-0.010	.958	✓			
0.254	+/-0.030	.251	✓			
1.40	+/-0.030	1.397	✓			
0.501	+/-0.010					
0.334	+/-0.010	.334	✓			
Ø0.328	+0.006/-0.001	.331	✓			
R0.156	+/-0.010	.156	✓			
1.20 Deep	+/-0.030					

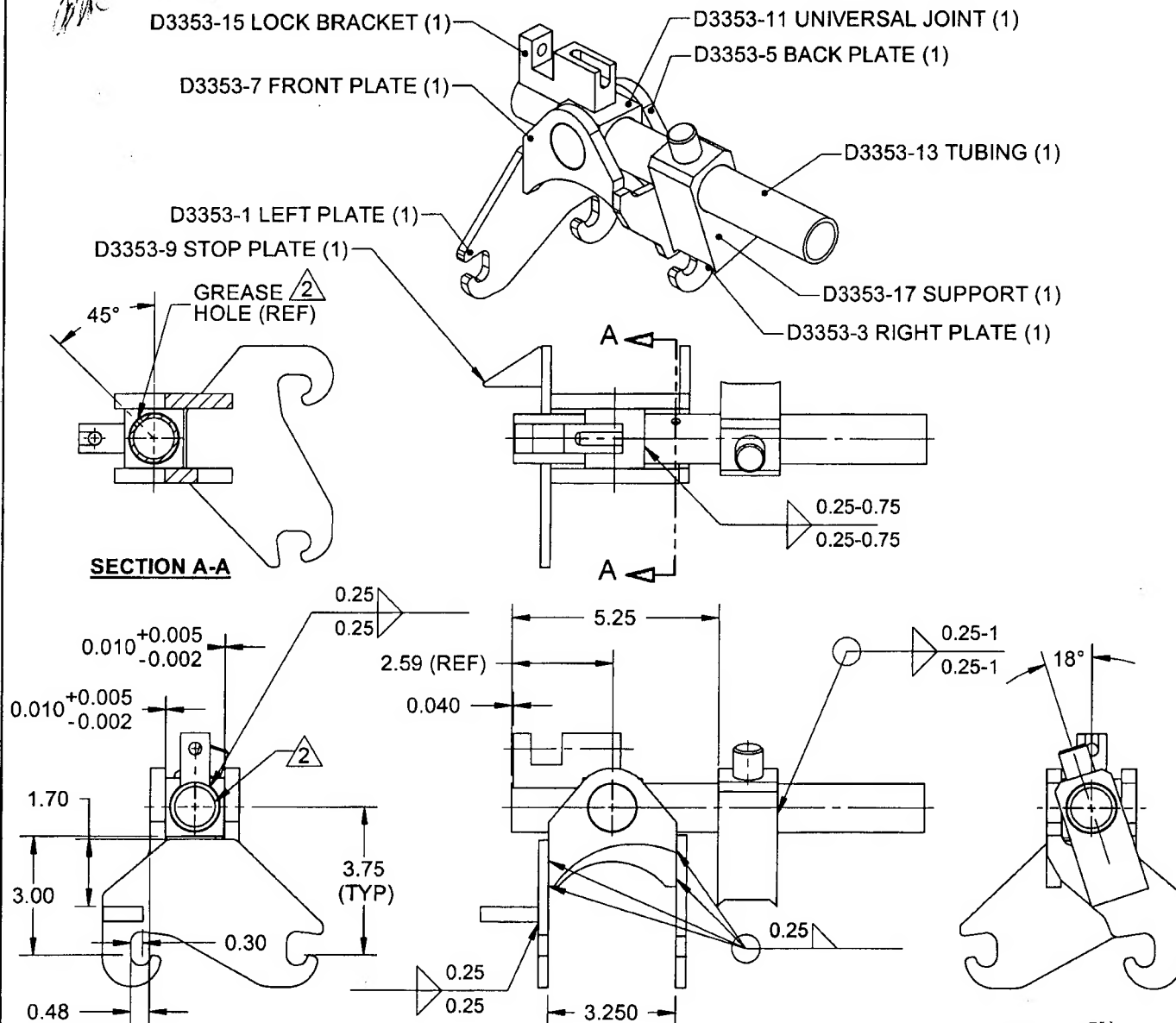
Measured by: J.L	Audited by: Sp	Prototype Approval:	N/A
Date: 06/12/05	Date: 06/12/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	



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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED
[Handwritten: 04/12/14]



D3353-041 LUG WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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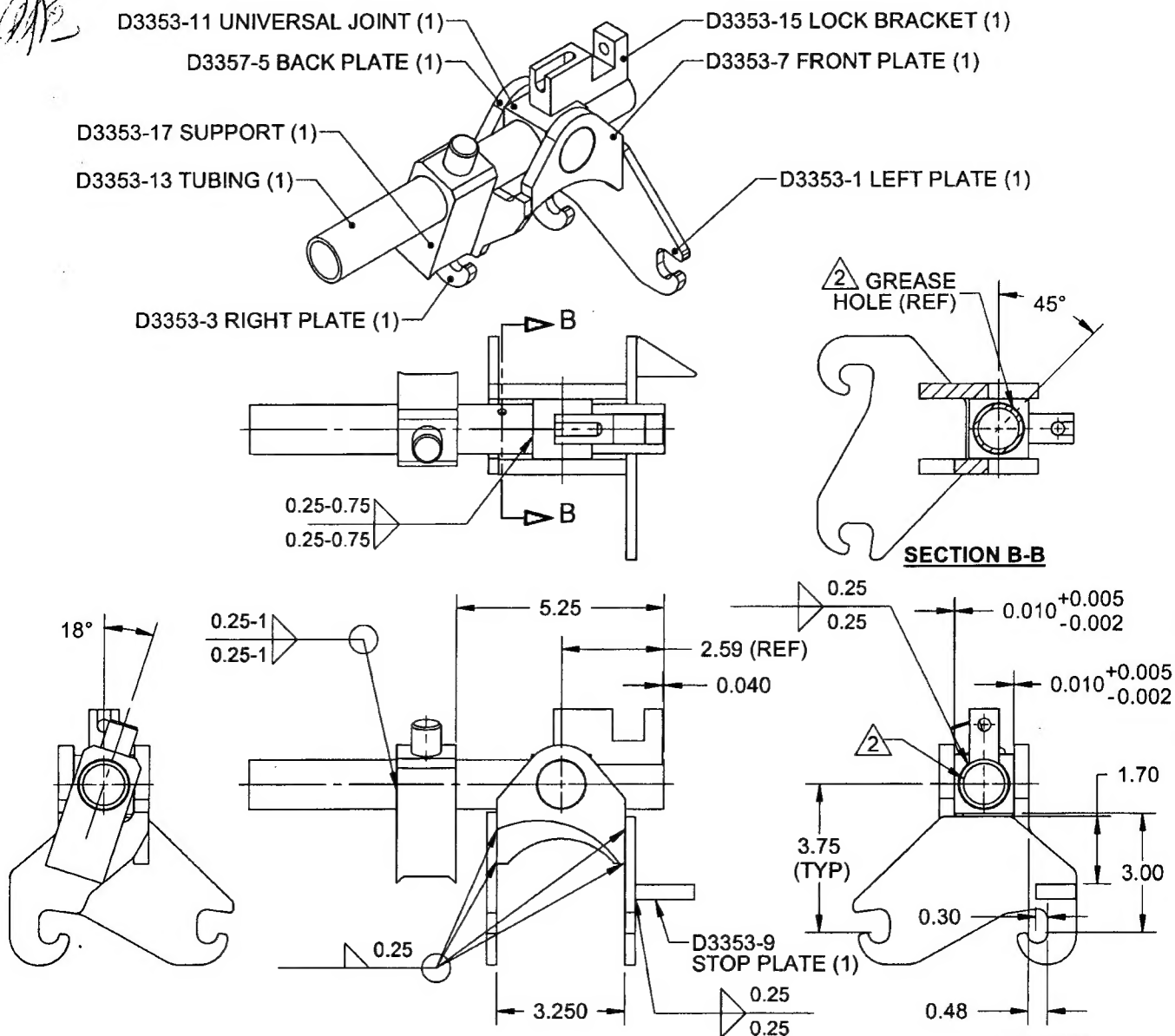
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4

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06/03/59



D3353-042 LUG WELDMENT

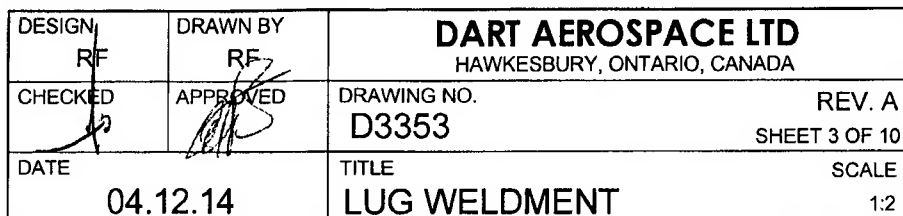
NOTES:

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- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

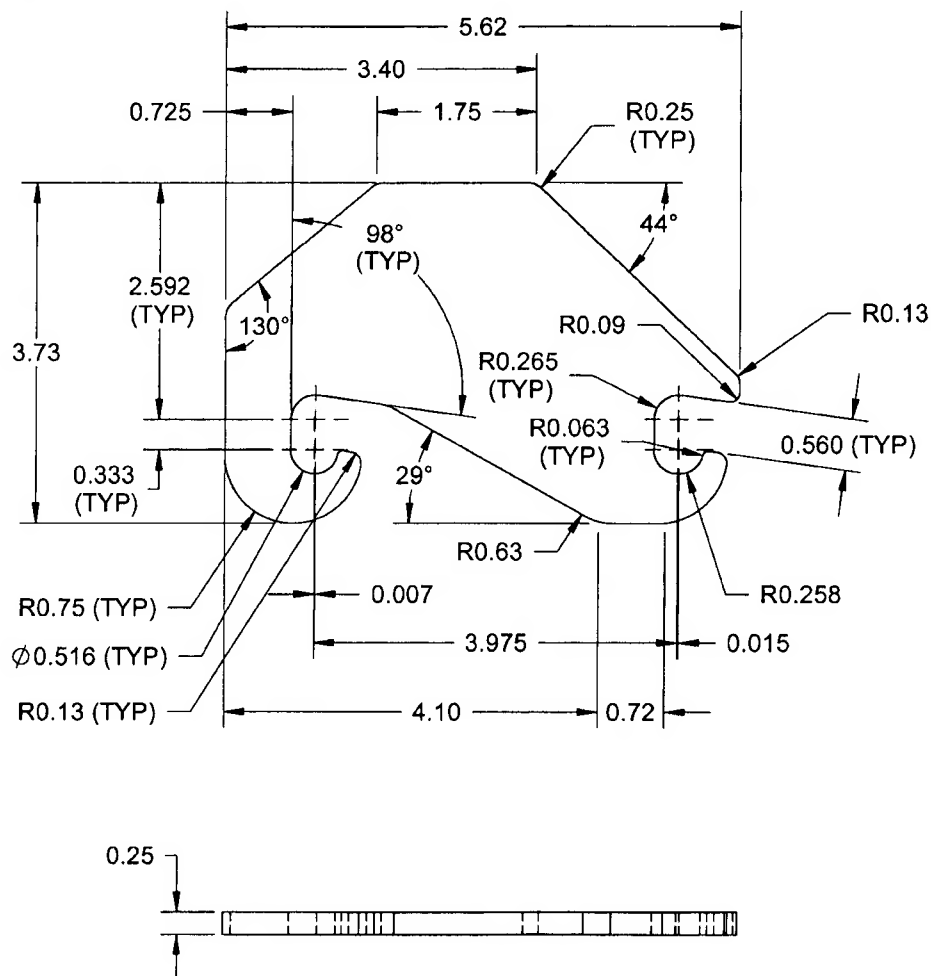
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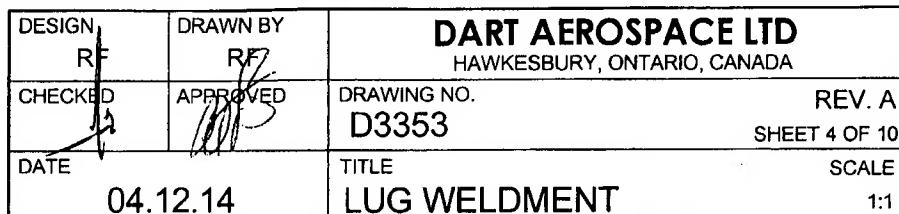
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

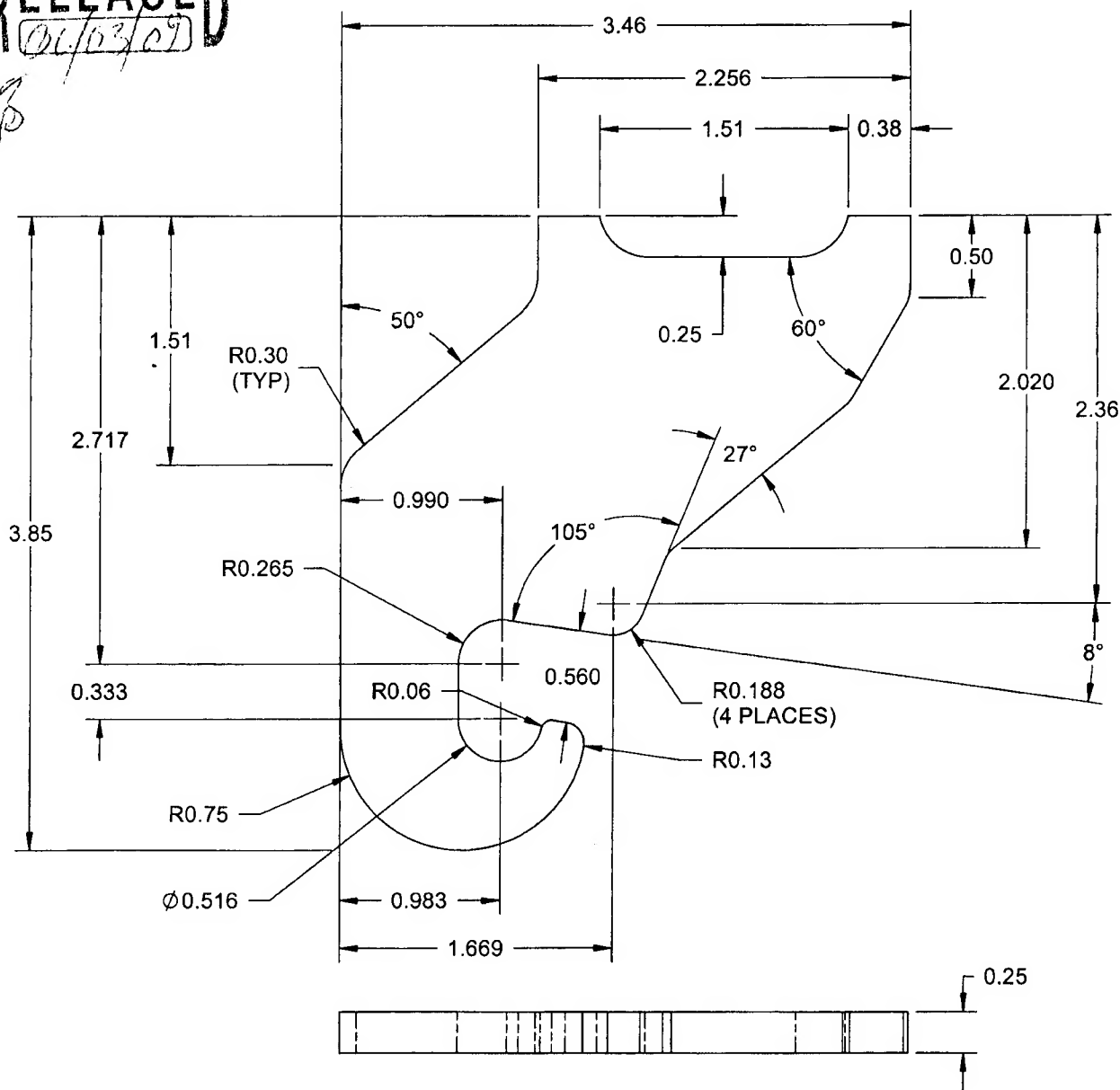
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38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

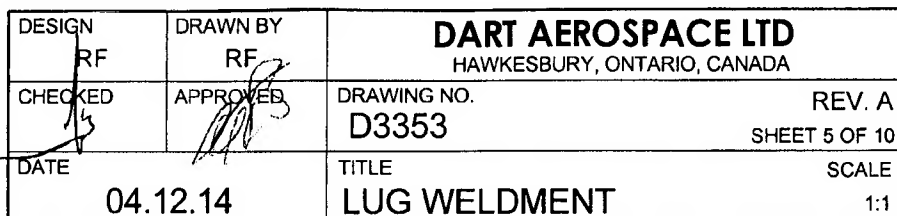
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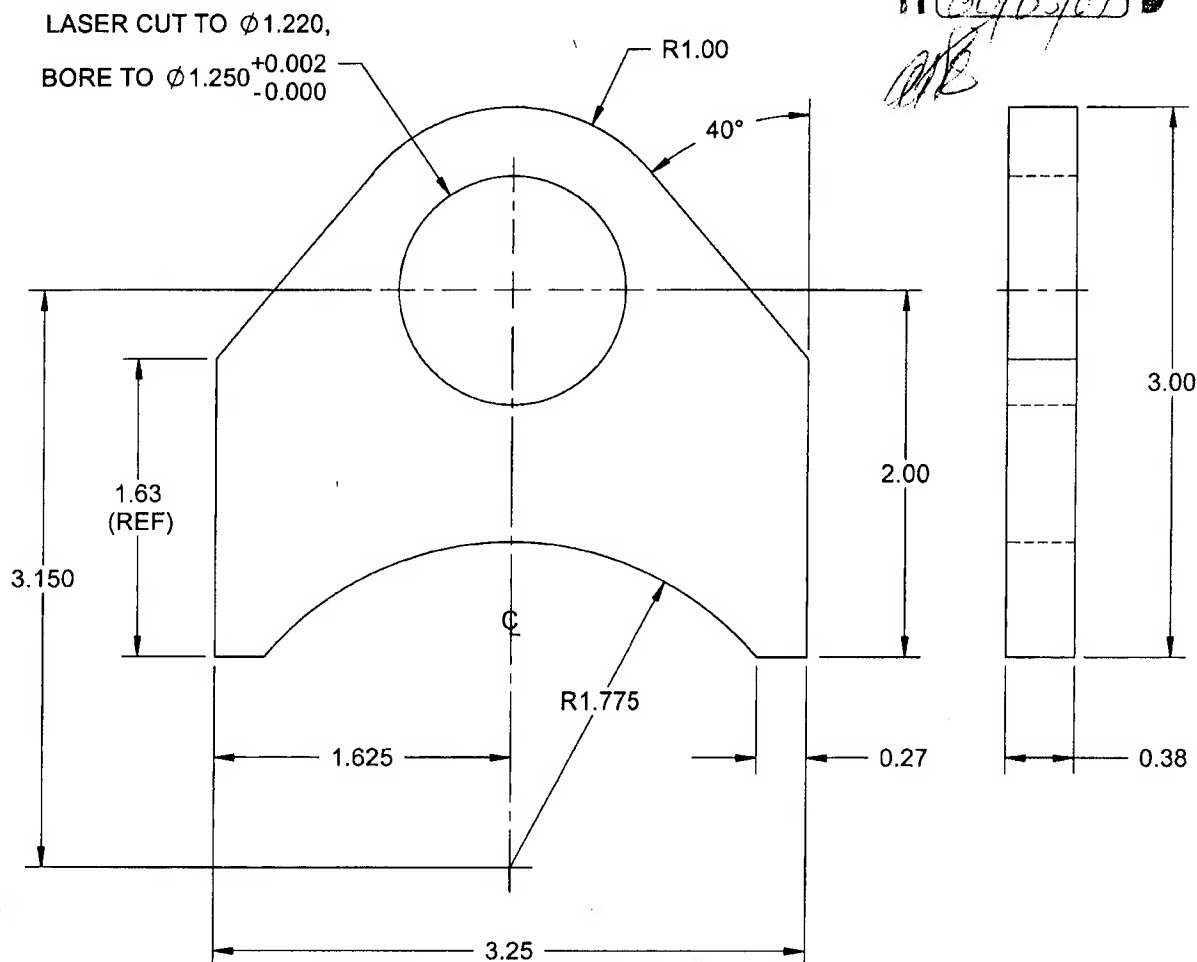
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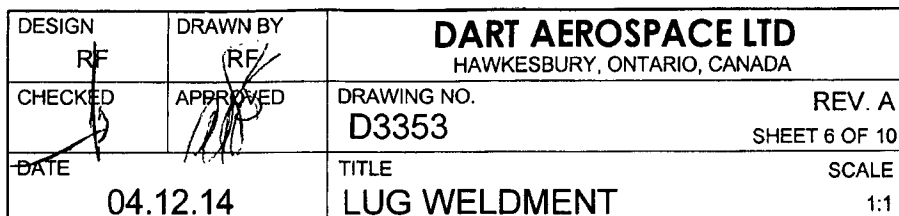
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR
CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

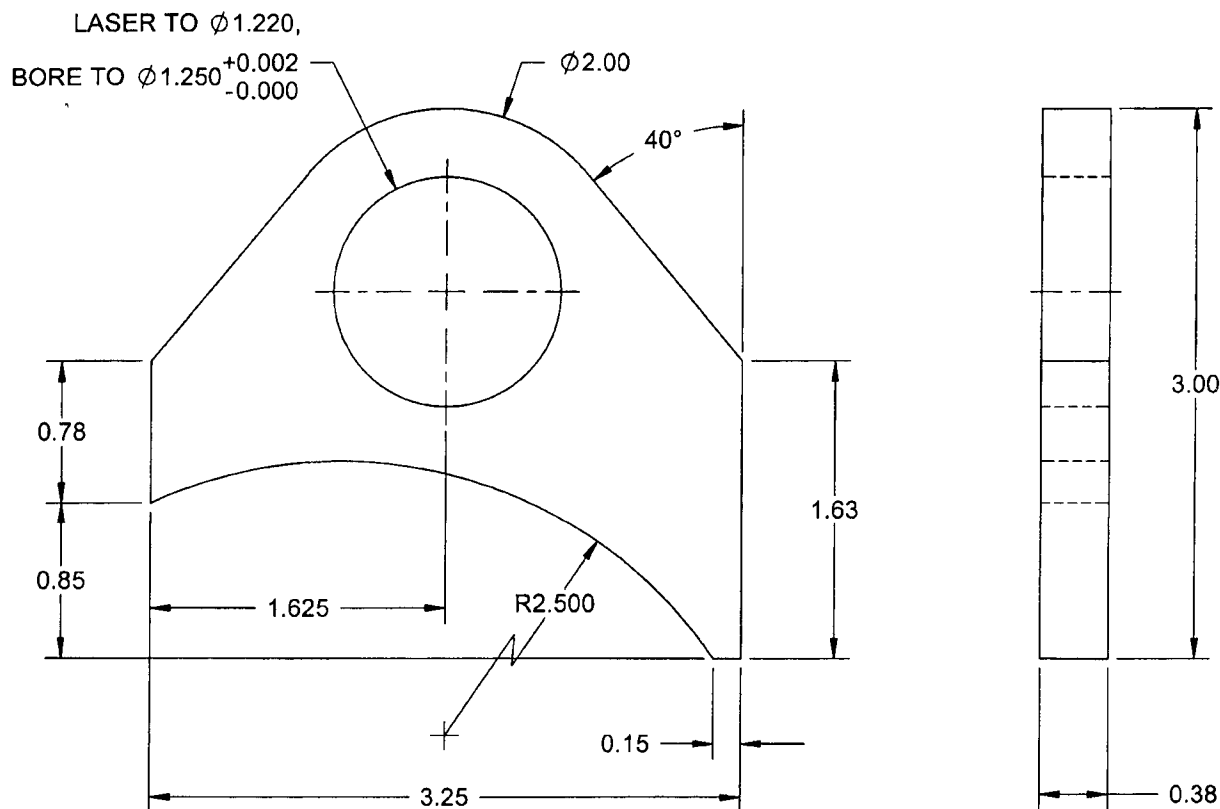
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06/03/07



D3353-7 FRONT PLATE

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR
CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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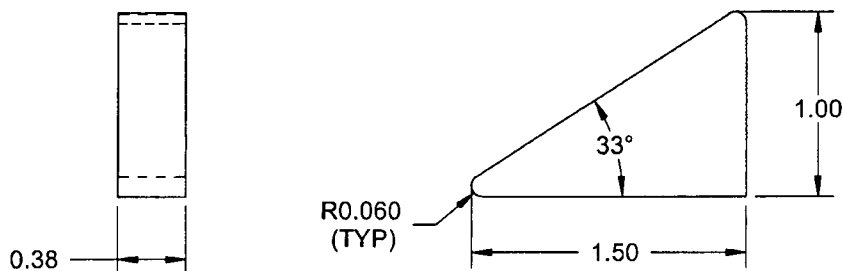
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

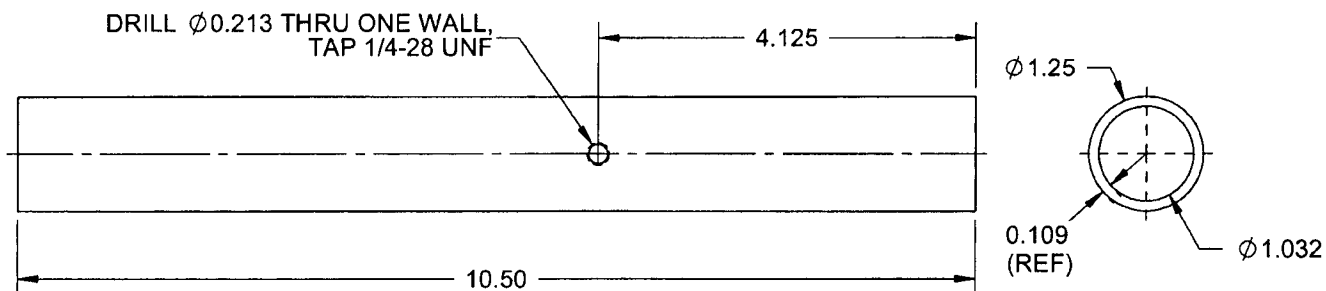
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D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)



D3353-13 TUBING

NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

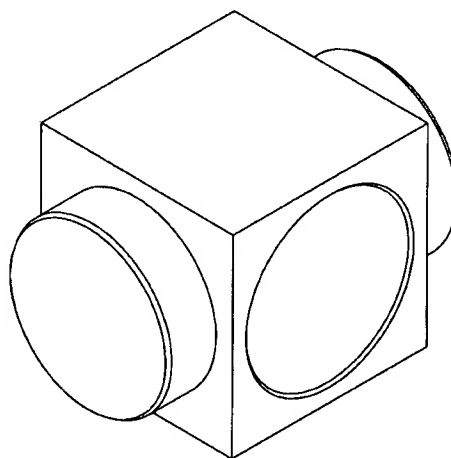
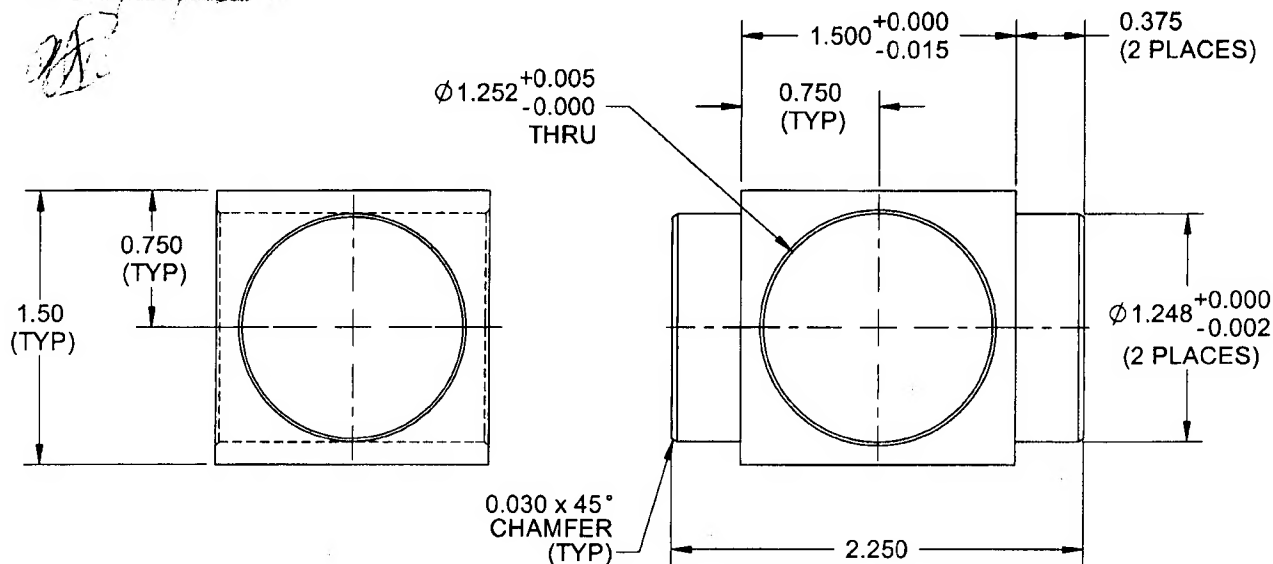
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

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[Signature]**D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

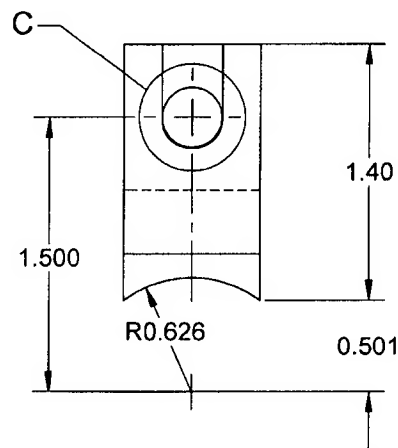
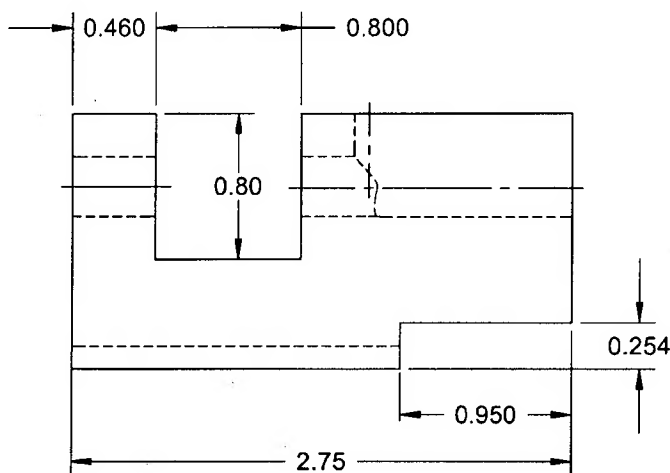
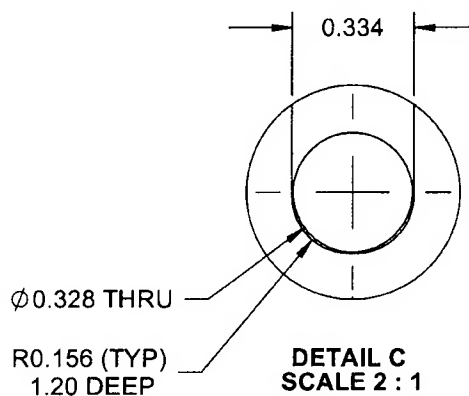
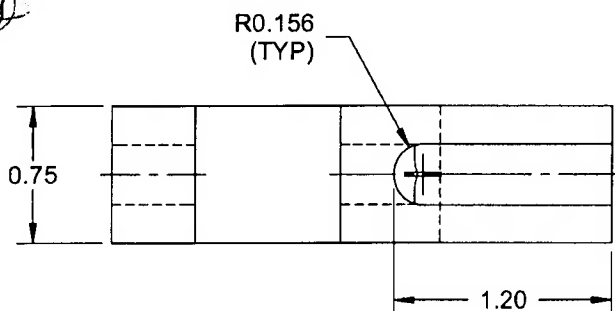
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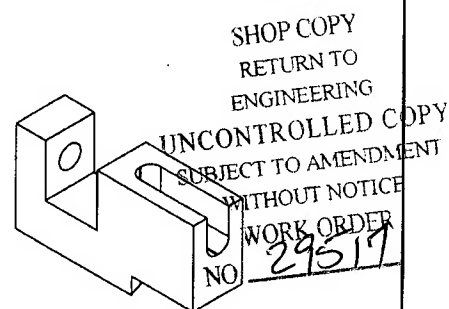
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

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06/02/09**D3353-15 LOCK BRACKET****NOTES:**

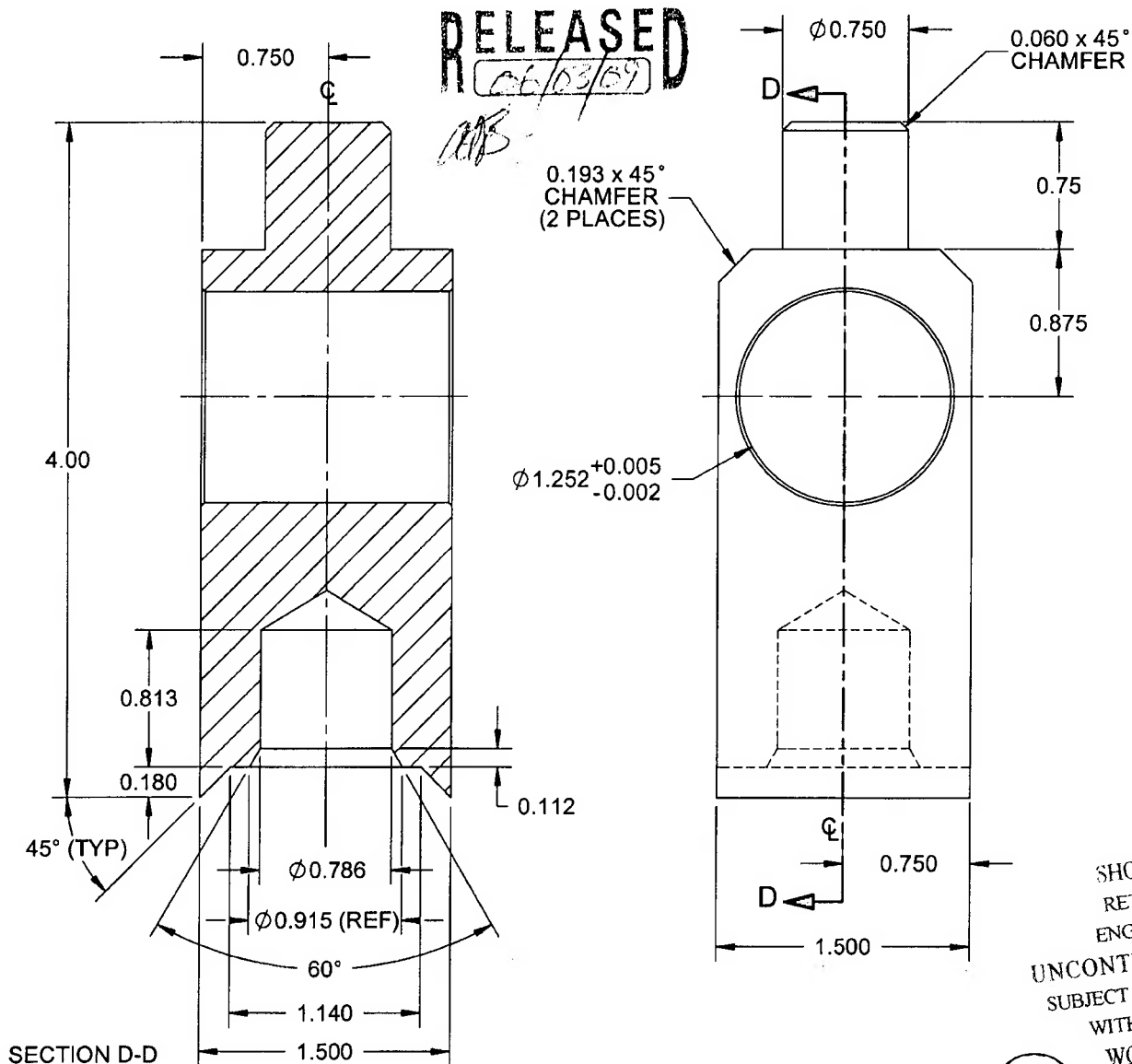
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW
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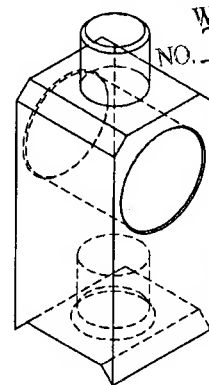
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1



D3353-17 SUPPORT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
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